

**Amendments to the Claims:**

The following claims will replace all prior versions of the claims in this application (in the unlikely event that no claims follow herein, the previously pending claims will remain):

- 1-18. (Cancelled).
19. (Currently amended) A metal working fluid comprising an ester according to the formula:



wherein

- X is an aliphatic hydrocarbyl group having 5-11 carbon atoms;
- Y is an alkylene group having 4-6 carbon atoms;
- Z is an a saturated linear aliphatic hydrocarbyl group having 4 carbon atoms and
- n is a weight average number between 1.5 and 10.

20. (Cancelled).
21. (Previously presented) The metal working fluid of claim 19 further comprising an oil selected from a mineral oil, a vegetable oil, or an animal oil.
22. (Previously presented) The metal working fluid of claim 19 further comprising a surfactant.
23. (Previously presented) The metal working fluid of claim 19 further comprising an emulsifier.

24. (Previously presented) The metal working fluid of claim 19 further comprising a corrosion inhibitor.
25. (Previously presented) The metal working fluid of claim 19 further comprising water.
26. (Previously presented) The metal working fluid of claim 19 further comprising a metal deactivator.
27. (Previously presented) The metal working fluid of claim 19 further comprising an anti-foam agent.
28. (Previously presented) The metal working fluid of claim 19 further comprising an anti-oxidant.
29. (Previously presented) The metal working fluid of claim 19 having a kinematic viscosity at 100°C less than 20mm<sup>2</sup>/s and a kinematic viscosity at 40°C of less than 150mm<sup>2</sup>/s.